

Work Order ID 78712

January-13-12 7:07:36 AM

78712

Page 1

Item ID: D3308-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Doubler

Stop ***NS2***

Start Date: 12/01/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: M.C.J Date: 12/01/13 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3308	Rev A								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3308 Dwg Rev: A Prog Rev: A 2-

Deburr if necessary

6061.063

1312-8-16

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1312-8-16

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

SMB

DAS 16

12/06/17

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

Deburr

N/A

140

140

HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Hand Finishing

6 78 12822

150

150

QC

QC3- Inspect Part Finish

Memo

0.00

0.00

Quality Control

60 12822

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Page 3

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NS1

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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 038

0.00

160

Packaging

Memo

0.00

Packaging

sl

6

8

12/08/22

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

WCS 12/08/23

MK
12-08-23

W/O:		WORK ORDER CHANGES					
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Picklist Print

January-13-12 7:07:40 AM

Page 1

Work Order ID: 78712

78712

Parent Item: D3308-1

D3308-1

Parent Item Name: Doubler

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A04.11.18New issueKJ/JLM
IPP Rev:B 08-05-12 now made on water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		110	sf	162.0696	0.0313	0.197684			

M6061T6S 063

B12-8-16

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

162.0695684

113608

0

116308

11.9555684

117285

75.414

119331

49.2

119802

25.5

171.858

(6)

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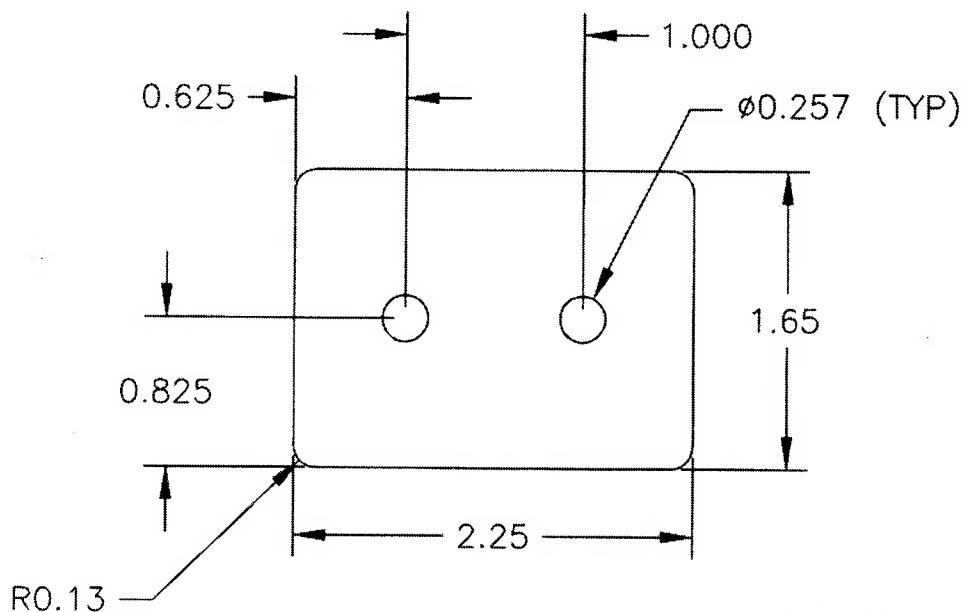
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DESIGN 71	DRAWN BY 74	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3308	REV. A SHEET 1 OF 1
DATE 04.10.13		TITLE DOUBLER	SCALE 1:1
A	04.10.13	NEW ISSUE	

RELEASED
04.11.23



D3308-1

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WITH RESPECT
TO INTELLECTUAL
PROPERTY

NO. 78712 M.C.J.
12/01/13

D3308-1 NOTES:

- 1) MATERIAL: 6061-T6 SHEET (QQ-A-250/11), 0.063 THICK
(REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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